



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2344
Job Sheet 179537



Part No: D2344

Job Qty: 1 ea

Part Name: Deck Plate Aft



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/20/18

Job Tracking No:

Due Date: 7/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV F IPP Rev:D 00.06.26 Removed P/O for powder coat EC IPP Rev:E 07-07-04 Asper Rev F JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea		7/16/18	0.00	0.00	Start Up Waterjet		SC 18/06/18
100	Waterjet	12 pcs		7/16/18	0.11	1.94	Waterjet1		SC 18/06/18
120	QC	12 pcs		7/16/18	0.00	0.00	QC8		38
130	Small Fab	12 pcs		7/16/18	0.00	1.59	Small Fab		9-89 DAS
140	QC	12 pcs		7/16/18	0.00	0.00	QC5		38
150	HandFinish	12 pcs		7/16/18	0.00	0.66	HandFinish1		SA 18-07-04
155	QC	12 pcs		7/16/18	0.00	0.00	QC7		18-7-5
160	Powdercoat	12 pcs		7/16/18	0.00	0.43	Powdercoat4		18-7-5
170	QC	12 pcs		7/16/18	0.00	0.00	QC3		38
180	Packaging	12 pcs		7/16/18	0.00	0.00	Packaging3	9225A	9-89 DAS
190	QC21-SA	12 Ea		7/16/18	0.00	0.00	QC21		9-89 DAS

Part Op 100 - 1-Cut as per dwg prog rev: F dwg rev: F

Descriptions: 130 - 1-Deburr sharp edges 2-Countersink holes per Dwg D2344

160 - START TIME: 8:20 CUT: 8:00 FINISH: 9:00 M13820

JUL 16 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.063	2024-T3 .063 Sheet	8.9400 sf (.745 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.063	9	212	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Litter Deck Plate Kit (350)	6.223Inches ± 0.010	6.233 6.213	6,220	
2	Litter Deck Plate Kit (350)	5.598Inches ± 0.010	5.608 5.588	5,600	
3	Litter Deck Plate Kit (350)	4.869Inches ± 0.010	4.879 4.859	4,870	
4	Litter Deck Plate Kit (350)	3.889Inches ± 0.010	3.899 3.879	3,890	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐								
Date : _____	Step #: _____	QTY Effective : _____		DART AEROSPACE Container No: S085189 Part: D2344 Job No: 179537 Serial No/ Batch: S085189 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____ Date: 06/28/18						
Description Work Order Deviation										
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%;"> Pr ☐ Be ☐ Cer ☐ Cra ☐ Crim ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:50%;"> Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> </tr> </table>		Pr ☐ Be ☐ Cer ☐ Cra ☐ Crim ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	<table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%;"> Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ </td> <td style="width:50%;"> Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mis-labeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> </tr> </table>	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mis-labeled ☐ Fit/Function ☐ Misaligned/off center ☐
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OTHER : _____										

5	Litter Deck Plate Kit (350)	3.096Inches ± 0.010	3.106 3.086	3,095
6	Litter Deck Plate Kit (350)	2.891Inches ± 0.010	2.901 2.881	2,890
7	Litter Deck Plate Kit (350)	16.973Inches ± 0.010	16.983 16.963	16,970
8	Litter Deck Plate Kit (350)	0.450Inches ± 0.010	0.460 0.440	0,454
9	Litter Deck Plate Kit (350)	4.423Inches ± 0.010	4.433 4.413	4,420
10	Litter Deck Plate Kit (350)	4.723Inches ± 0.010	4.733 4.713	4,720
11	Litter Deck Plate Kit (350)	1.202Inches ± 0.010	1.212 1.192	1,200
12	Litter Deck Plate Kit (350)	5.869Inches ± 0.010	5.879 5.859	5,870
13	Litter Deck Plate Kit (350)	4.654Inches ± 0.010	4.664 4.644	4,660
14	Litter Deck Plate Kit (350)	0.656Inches + 0.005 - 0.000	0.661 0.656	0,656 Diameter
15	Litter Deck Plate Kit (350)	1.888Inches ± 0.010	1.898 1.878	1,888
16	Litter Deck Plate Kit (350)	2.285Inches ± 0.010	2.295 2.275	2,280
17	Litter Deck Plate Kit (350)	2.683Inches ± 0.010	2.693 2.673	2,680
18	Litter Deck Plate Kit (350)	0.171Inches + 0.005 - 0.000	0.176 0.171	0,173 Diameter
19	Litter Deck Plate Kit (350)	3.491Inches ± 0.010	3.501 3.481	3,490
20	Litter Deck Plate Kit (350)	0.191Inches + 0.005 - 0.000	0.196 0.191	0,192 Diameter
21	Litter Deck Plate Kit (350)	3.123Inches ± 0.010	3.133 3.113	3,120
22	Litter Deck Plate Kit (350)	1.975Inches ± 0.010	1.985 1.965	1,975
23	Litter Deck Plate Kit (350)	0.128Inches + 0.005 - 0.001	0.133 0.127	0,130 Diameter

Plex 6/20/18 8:28 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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